

RADIOGRAPHIC TESTING OF BUTT WELDS

(4-1-95)

~~Radiographic testing of butt welds shall be performed in accordance with the ANSI/AASHTO/AWS Bridge Welding Code, Section 1072 of the Standard Specifications and this Special Provision.~~

1072-20(F)

Edge blocks shall be used when radiographing butt welds greater than 1/2 inch in thickness. The edge blocks shall have a length sufficient to extend beyond each side of the weld centerline for a minimum distance equal to the weld thickness, but not less than 2 inches, and shall have a thickness equal to or greater than the thickness of the weld. The minimum width of the edge blocks shall be equal to half the weld thickness, but not less than 1 inch. The edge blocks shall be centered on the weld with a snug fit against the plate being radiographed allowing no more than 1/16 inch gap. Edge blocks shall be made of radiographically clean steel and the surface shall have a finish of ANSI 125 or smoother.